

Wednesday, 5/16/2007 8:13:15 AM
Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
 Job Number : 32373
 Estimate Number : 11057
 O. Number : *N/A*
 Issue : 5/16/2007 S.O. No. : *N/A*
 Revisht Rev. : NC
 First Issue : *N/A*
 Previous Run : 29108
 Written By : *[Signature]*
 Checked & Approved By : *[Signature]*
 Comment : Est. C 02.11.26 Added P/O KJ
 Additional Product

Drawing Name : 02.250 SUPPORT
 Part Number : D28911
 Drawing Number : D2891 REV A1
 Project Number : N/A
 Drawing Revision : A1
 Material : *N/A*
 Due Date : 6/5/2007
 Qty : *Split* Um: Each

Job Number:



Description:

Seq. #:

Machine Or Operation:

PURCHASING

1.0

PG



Comment: PURCHASING

Issue P/O: *3795**Lo 7/05/17**(16)*

Description: D6104-003

Material: 17-4 PH SS (AMS 5643 OR AISI 630) as per Dwg D6104

Material release note required.

Blank size makes (2) D2891-1

17-4 SS Roundbar 3.25"OD

2.0

D6104003



Comment: Qty.: 1.0000 Each(s)/Unit Total: 16.0000 Each(s)

Support 2.25 dia

3.0

PACKAGING 1



PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect for Transit Damage

Ensure Material Release Note is attached

MORI SEIKI CNC LATHE LARGE

4.0

MORI SEIKI



Comment: MORI SEIKI LATHE

Turn blank for Haas as per Folio FA046

INSPECT ALL DIM TO DIM SHEET

5.0

QC1



Comment: INSPECT ALL DIM TO DIM SHEET

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 02.250 SUPPORT

Job Number: 32373

Part Number: D28911

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

HAAS1

HAAS CNC VERTICAL MACHINING #1



Comment: HAAS

Machine as per Folio FA046

Tumble & Deburr

INSPECT PARTS AS THEY COME OFF MACHINE

7.0

QC2



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SECOND CHECK

8.0

QC8



Comment: SECOND CHECK

SPRAY PAINTING

9.0

SPRAY PAINTING



Comment: SPRAY PAINTING

-PRIME

- PAINT DELFLEET BLUE

-CLEAR DELFLEET

10.0

QC14



INSPECT SPRAY PAINT



Comment: INSPECT SPRAY PAINT

11.0

PACKAGING 1



PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

FINAL INSPECTION/W/O RELEASE

12.0

QC21



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



Inspect dimensions highlighted on inspection sheet drawing D2891 Rev.A1/DSK076 Rev.A and record below:

| | | | | Recorded Actual Dimensions | | | | | |
|---------------|-------|-------|----------------|----------------------------|-------|--------|--------|----|------|
| Dim | Min | Max | Go/No Go Gauge | 1 | 2 | 3 | 4 | By | Date |
| Lathe Section | | | | | | | | | |
| A | 2.274 | 2.279 | | 2.275 | 2.276 | 2.278 | 2.277 | | |
| B | 3.702 | 3.722 | | 3.680 | 3.712 | 3.712 | 3.710 | | |
| C | 2.564 | 2.584 | | 2.574 | 2.574 | 2.574 | 2.574 | | |
| D | 0.718 | 0.738 | | .733 | .730 | .730 | .730 | | |
| E | 0.090 | 0.110 | | .087 | .090 | .090 | .090 | | |
| F | 2.464 | 2.484 | | 2.474 | 2.474 | 2.474 | 2.474 | | |
| G | 2.029 | 2.049 | | 2.032 | 2.032 | 2.032 | 2.032 | | |
| H | 2.964 | 2.984 | | 2.974 | 2.974 | 2.974 | 2.974 | | |
| I | 0.913 | 0.933 | | .918 | .919 | .919 | .919 | | |
| J | 0.022 | 0.042 | | .032 | .032 | .032 | .032 | | |
| K | 0.090 | 0.110 | | .099 | .099 | .099 | .098 | | |
| L | | | | | | | | | |
| HAAS Section | | | | | | | | | |
| AA | 0.188 | 0.193 | DT8706 | | | Ø.189" | Ø.189" | | |
| AB | 0.240 | 0.260 | | | | .242" | .242" | | |
| AC | 0.115 | 0.150 | | | | .125" | .125" | | |
| AD | 0.040 | 0.060 | | | | .050" | .050" | | |
| AE | 0.010 | 0.020 | | | | .015" | .015" | | |
| AF | 0.240 | 0.260 | | | | Ø.250" | Ø.250" | | |
| AG | 0.290 | 0.310 | | | | .305" | .305" | | |
| AH | 0.115 | 0.150 | | | | .125" | .125" | | |
| AI | 0.454 | 0.474 | | | | .456" | .462" | | |
| AJ | 2.779 | 2.789 | | | | 2.784" | 2.784" | | |
| AK | 0.240 | 0.260 | | | | Ø.250" | Ø.250" | | |
| AL | 1.002 | 1.042 | | | | 1.041" | 1.042" | | |
| AM | 0.053 | 0.073 | | | | Ø.063" | Ø.063" | | |
| AN | 0.257 | 0.262 | DT8683 | | | Ø.257" | Ø.257" | | |
| AO | 1.663 | 1.683 | | | | 1.670" | 1.672" | | |
| AP | 0.053 | 0.073 | | | | Ø.063" | Ø.063" | | |
| AQ | 0.022 | 0.042 | | | | Ø.022" | Ø.022" | | |
| AR | | | | | | | | | |
| AS | | | | | | | | | |
| Accept/Reject | | | | | | | | | |

Measured by: SEI / JF 07/06/27
 Date: 07/06/07 / 07/06/27
 Audited by: SA
 Date: 07.06.27

| Rev | Date | Change | Revised by | Approved |
|-----|----------|-----------|------------|----------|
| A | 07.12.12 | NEW ISSUE | KURE | |